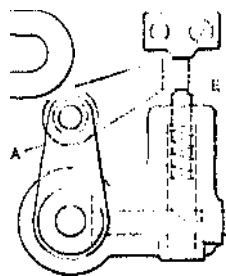


the clamp is hooked over the flange. Care must be taken that the point *X* is below the pivot point of the piece *C*.

Fig. 17 illustrates part of a heavy milling fixture for clamping against the stop-plate *A*, by means of the two plungers *B* and *C*, by equalizing with the plunger *D* and sleeve *E* working against *B* and *C* with 45-degree wedge cuts. Projections on the work often prevent the use of plain clamps. Fig. 18 shows a resort



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A

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POO POINT HC HCW



Fig. 15. Another Double Movement Clamping
Mcr,huui;;m

to an unusual^ but efficient, clamp to meet these conditions, The use of plungers *A* and *B* permits the clamp to be operated from the rear by means of a screw *C* and knob *D*). When work is long in proportion to its width or when the locating pins must be placed close together, as in the pirn? illustrated in Fig. 19, there is danger of it "cocking" or binding between one locating pin and the screw? if a plain screw is used to throw the work